



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW0805G00231-3G

Job Sheet 172567



cell 30

Part No: RBW0805G00231-3G

Job Qty: 9 ea

Part Name: Adapter Assembly Helicopter Weighing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW0805G00231-3G REV N/A IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	9 pcs		4/30/18	0.00	0.00	Purchasing		AT 18/04/26
110	Packaging	9 pcs		4/30/18	0.00	0.00	Packaging2		AT 18/04/26
120	QC	9 pcs		4/30/18	0.00	0.00	QC6		38
130	Packaging	9 pcs		4/30/18	0.00	0.00	Packaging3		APR 27 2018
140	QC21-FG	9 Ea		4/30/18	0.00	0.00	QC21		GA 109

Part Op 100 - Issue P/O: 039084 MANUFACTURE RBW0805G00231-3G AS PER DWG Supplier: ARROW TECH MACHINE
Descriptions: WORKS Certificate of conformity is required

9-88

FEB 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW0805G00231-3GP	Adapter Assembly Helicopter Weighing	9 (1 ea)	100-Purchasing	5065979

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW0805G00231-3GP	9	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



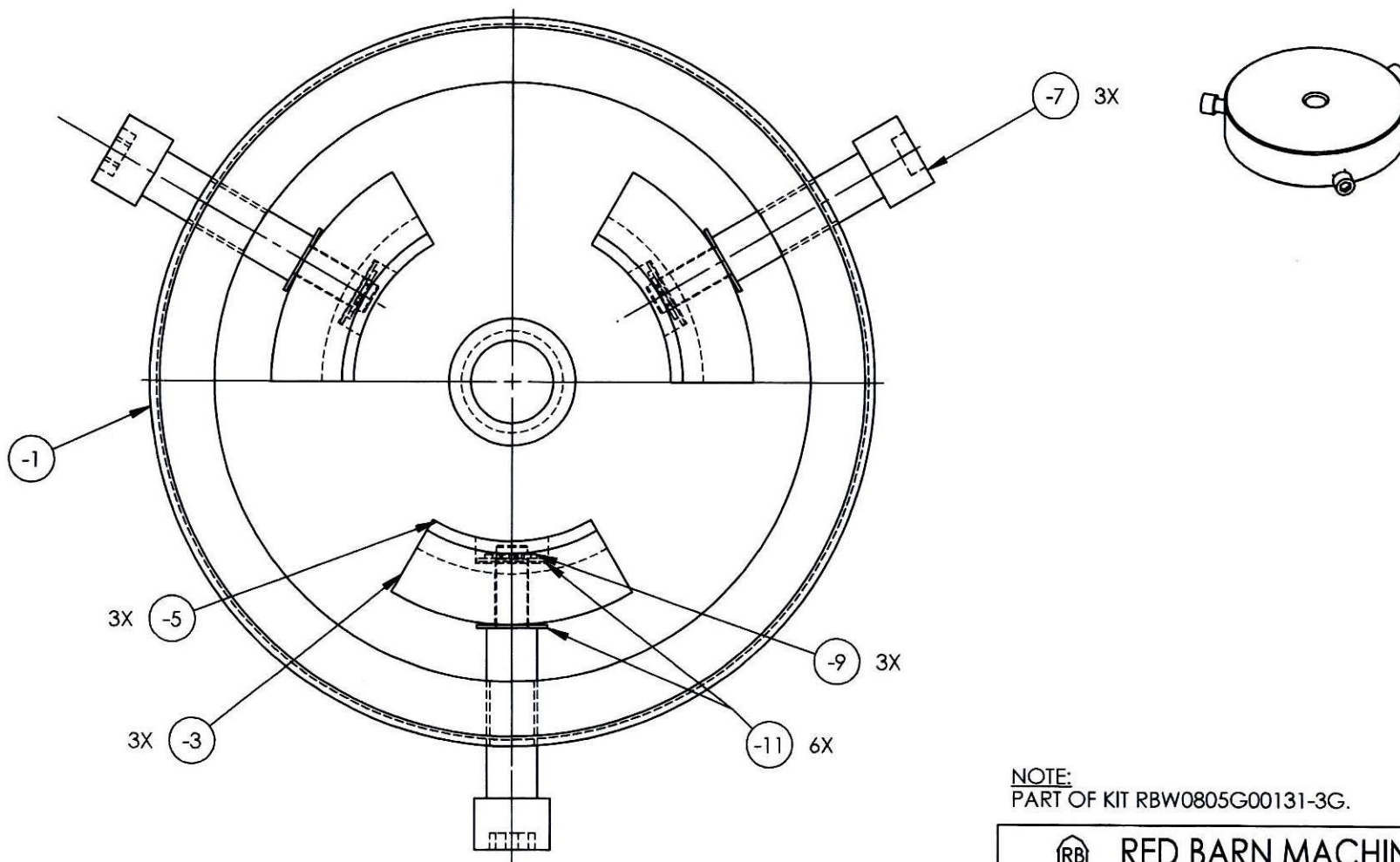
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:25%;">Skid-tube ☐</td> <td style="width:25%;">Cross tube ☐</td> <td style="width:25%;">Water Jet ☐</td> <td style="width:25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td></td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		Composite ☐	Supplier ☐				
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	Composite ☐	Supplier ☐																					
Date : _____ Des: _____	Job No: 172567 Mfg Date: 04/26/18 Packaging Operation: Revision: Serial No/Batch: S065880 PART NO: RBW0805G00231 - 3G Adapter Assembly Helicopter Weighing Container No: S065880 DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																			
Root Cau <table style="width:100%;"> <tr> <td style="width:25%;">Environment ☐</td> <td style="width:25%;">Design ☐</td> <td style="width:25%;">Doc/Data ☐</td> <td style="width:25%;">Equip/Tooling ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Material ☐</td> <td>Internal Transport ☐</td> <td>Tribal Knowledge ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Substation ☐</td> <td>Past Expiry Date ☐</td> <td>Misidentified ☐</td> </tr> </table>	Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	<table style="width:100%;"> <tr> <td style="width:25%;"> Offsets/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:25%;"> Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:25%;"> Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:25%;"> Power Loss/Surge ☐ I/O/Program ☐ Main ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> <tr> <td colspan="4"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>			Offsets/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ I/O/Program ☐ Main ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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OTHER : _____																							

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



NOTE:
PART OF KIT RBW0805G00131-3G.



RED BARN MACHINE

TITLE
ADAPTER ASSY, HELICOPTER WEIGHING

DWG NO. RBW0805G00231-3G-1 REV

MATERIAL		DRAWN BY: MARPET	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .005	FRACTIONS ± 1/32	HEAT TREAT	
.XX ± .01	ANGLES ± 5°	FINISH	
.X ± .1		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		AGUSTA	
SCALE	1:1	DATE	2/8/2013
		SHEET 1 OF 5	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	1018	Ø4-1/2 X 1	2
			-3	3	SHOE	1018	Ø3 X 1	3
			-5	3	PAD	WHITE DELRIN	Ø2-1/2 X 3/4	4
			-7	3	CLAMP BOLT	STEEL	5/16-24 X 2 HEX HEAD CAP SCREW (MCMASTER-CARR # 92200A657) (MOD)	5
		B/O	-9	3	SIDE MOUNT RETAINING RING	STEEL	3/16 (MCMASTER-CARR #98407A118)	1
		B/O	-11	6	FLAT WASHER	STEEL	#10 (MCMASTER-CARR #95229A370)	1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039084

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO039084
PO Date: 2/21/18
Due Date: 4/30/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

E-MAILED
MAR 06 2018

Ship To:

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	RBSC7028-PP			Portable Bearing Cutter As Per Dwg RBSC7028-P Rev.6	Firmed	4/6/18	7 pcs	0 pcs	7 pcs	\$843.42/pcs	\$5,903.94
Line Item Note job# 172595											
2	RBE703A94-3000-00-1P			Wide Frame Assembly As Per Dwg RBE703A94-3000-00-1 Rev. 1	Firmed	3/20/18	3 Ea	0 Ea	3 Ea	\$2,417.56/Ea	\$7,252.68
Line Item Note job# 172374											
3	RBE703A94-3000-00-3P			Narrow Frame Assembly As Per Dwg RBE703A94-3000-00-3	Firmed	3/20/18	3 Ea	0 Ea	3 Ea	\$2,417.56/Ea	\$7,252.68
Line Item Note job# 172375											
4	RBW0805G00231-3GP			Adapter Assembly Helicopter Weighing As Per Dwg RBW0805G00231-3G-1	Firmed	4/30/18	9 Ea	0 Ea	9 Ea	\$564.82/Ea	\$5,083.38
Line Item Note job# 172567											
5	RBW6405G08832-3GP			Tail Rotor Bushing Install Tool As Per Dwg RBW6405G08832-3G Rev/ D	Firmed	4/30/18	3 Ea	0 Ea	3 Ea	\$809.13/Ea	\$2,427.39
Line Item Note job# 172623											
6	RBW6405G08732-3GP			Tail Rotor Bushing Removal Tool RBW6405G08732-3G Rev. E	Firmed	4/30/18	3 Ea	0 Ea	3 Ea	\$459.38/Ea	\$1,378.14
Line Item Note job# 172622											
7					Firmed	4/16/18	5 Ea	0 Ea	5 Ea	\$618.50/Ea	\$3,092.50



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:039084

Dated: 04/24/2018

Our Order / Job No: 24AWT

Order Qty: 9

Part Name: Adapter Assy, Helicopter Weighting

Part Number: RBW0805G00231-3G

Lot Size: N/A

Ship Date: 04/24/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW0805G00231-3G

Rev: 0

Material Size and Type: -1/1018 STEEL; -3/1018 STEEL; -5/ WHITE DELRIN

Material Specifications: STEEL: ASTM A108, ASTM A29

Heat Treatment: N/A

Plating/Finish: ZINC PLATE: ASTM B633 TYPE I SC2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date:

4/24/18

Signed:

Herman Feld

DAS
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APR 27 2018

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.attechmachineworks.com